

ASAP

Date: Monday, 7/9/2007 11:47:31 AM
 User: Kim Johnston

Process Sheet

SPLIT-2

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOAT WEB	
Job Number	: 33373				
Estimate Number	: 10791				
P.O. Number	: N/A		Part Number	: D3282041	
This Issue	: 7/9/2007 S.O. No. : N/A		Drawing Number	: D3282 REV C	
Prsht Rev.	: NC		Project Number	: N/A	
First Issue	: N/A		Drawing Revision	: C	
Previous Run	: 33224		Material	: N/A	
Written By			Due Date	: 7/20/2007 Qty: 6 Um: Each	
Checked & Approved By					
Comment	: Est Rev:B 05.09.23 Procedure change KJ/JLM				

Additional Product

Job Number:



Seq #: Machine Or Operation: Description :

1.0 D2792130 EXTRUSION



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2792-130	Extrusion	<i>B24030</i>
Identify as D3282-1			

DP 7-7-12

(8)

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut to length as per Dwg D3282.

DP 7-7-12

(8)

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA579 & Dwg D3282

2-Deburr

ml 07/07/19

(6)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 07/07/19

(6)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 07/07/19

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:31 AM
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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7-7-20

7.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



QC3 07/20(6)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0 D32831

Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number
2 D3283-1

Description
Doubler

Batch

B 52477 (13)

7-7-20

9.0 MS20470AD47

Rivet, Universal Head



Comment: Qty.: 57.0000 Each(s)/Unit Total : 456.0000 Each(s)

Pick:

Qty Part Number
57 MS20470AD4-7

Description
Rivet

Batch

M 00854 (285) M 04291 (57)

7-7-20

10.0 LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install doublers as per Dwg D3282. Apply LPS-3 between doublers and web
A/RN/ALPS-3 M 04929

7-7-21

11.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-7-23 (4)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 46

DP 7-7-23

W/I/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 01/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 7/9/2007 11:47:31 AM
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Drawing Name: FLOAT WEB

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Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

F 09/07/04

Job Completion



U 09/07/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33373
Description: Float Web	Part Number:	D3282-041
Inspection Dwg: D3282 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

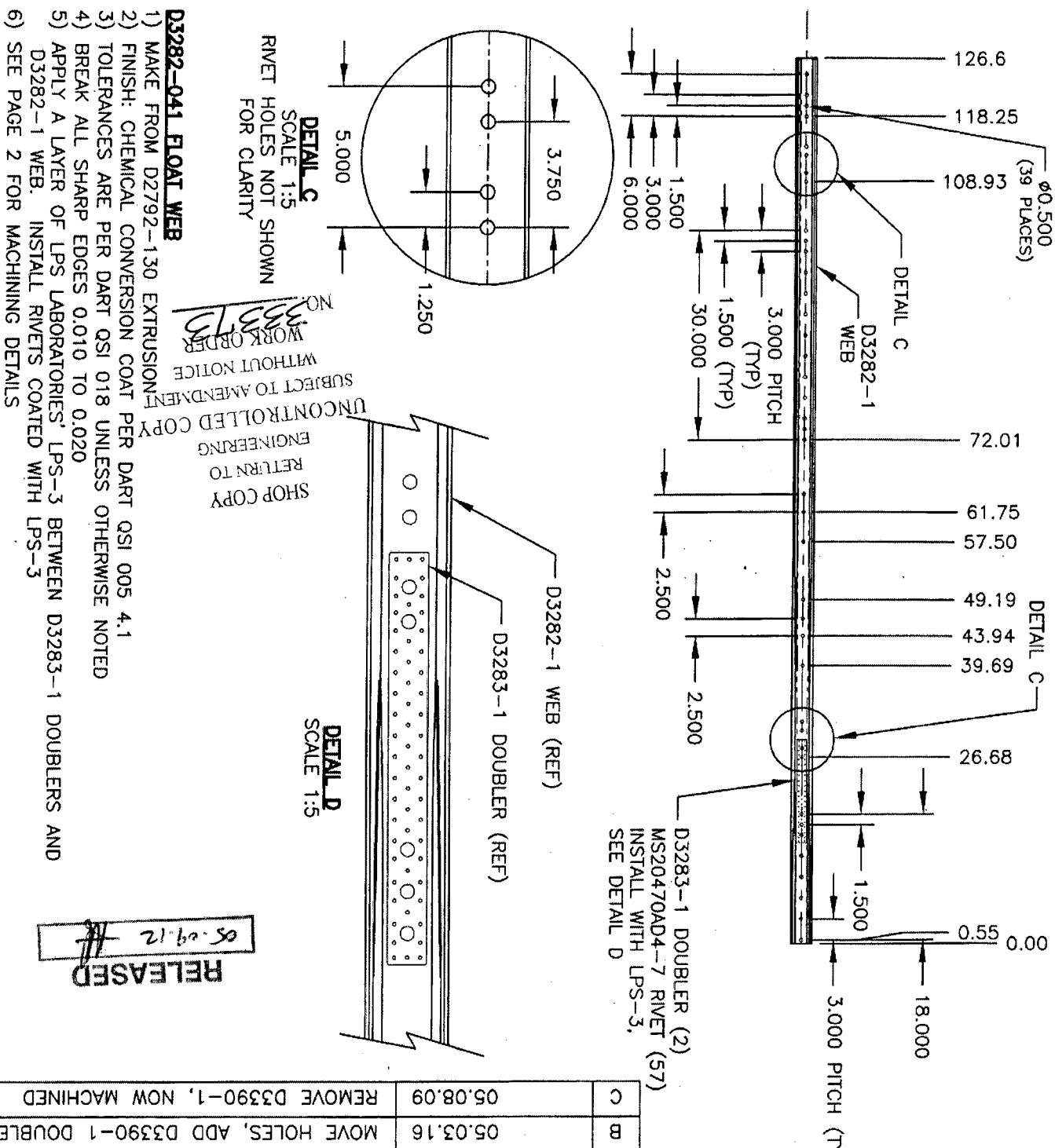
X First Article Prototype

Measured by:	<u>gmk</u>	Audited by:	<u>SA</u>	Prototype Approval:	N/A
Date:	07/07/17	Date:	01.01.19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.04.02	New Issue	KJ/JLM	<i>[Signature]</i>

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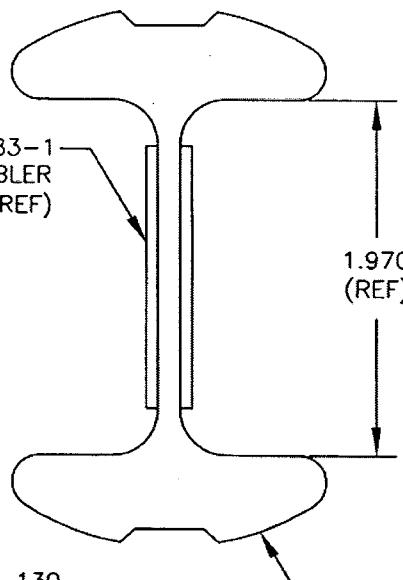
DESIGN	DRAWN BY	CD	CHECKED	APPROVED	REV. C	DRWING NO.	TITLE	DATE	SCALE
						D3282	FLOAT WEB, 206L/407	05.08.09	1:20
A	04.05.05	NEW ISSUE						05.03.16	MOVE HOLES, ADD D3390-1 DOUBLERS
B	05.08.09	REMOVE D3390-1, NOW MACHINED							
C	05.08.09	MOVE HOLES, ADD D3390-1 DOUBLERS							

DART

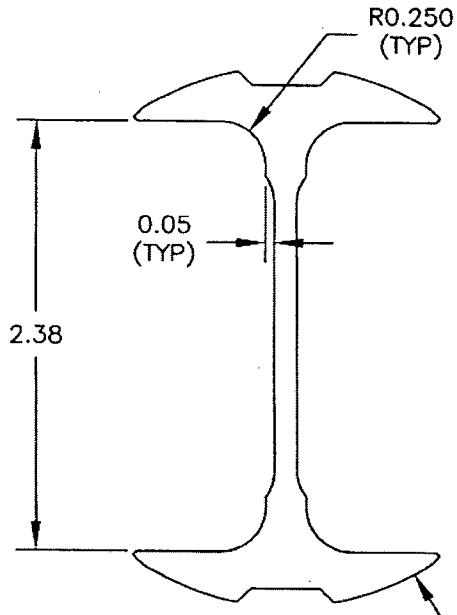
DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC.
CHECKED	APPROVED	PORT HADLOCK, WA
DATE	TITLE	REV. C
05.08.09	FLOAT WEB, 206L/407	SHEET 2 OF 2
		SCALE 1:20

SECTION B-B

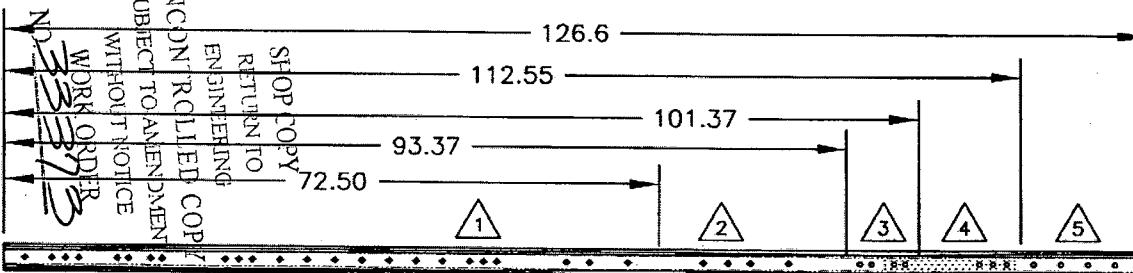


SECTION A-A



D3282-1 MACHINING NOTES

- 1 UNIFORM SECTION A-A
- 2 UNIFORM TAPER FROM SECTION A-A TO SECTION B-B
- 3 UNIFORM SECTION B-B
- 4 UNIFORM TAPER FROM SECTION B-B TO SECTION A-A
DRILL #30 ($\phi 0.128$ REF) HOLES (57 PLACES) TO LINE UP WITH D3283-1,
SEE DETAIL D FOR REFERENCE
- 5 UNIFORM SECTION A-A
- 6 R1.00 BETWEEN SECTIONS



RELEASED